

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019992**Date Inspected:** 05-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** SHANGHAI CHINA

CWI Name:	Mr. Huang Min		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** OBG BAY 6 to 8**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 6

FCAW welding of welds joint CB3002J-001-011/012, And Welder is identified as 053609, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2134.

FCAW welding of welds joint CB3002J-002-111/112, And Welder is identified as 204342, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2133.

FCAW welding of welds joint CB3002K-003-011/012, And Welder is identified as 051246, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-22134.

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Shielded Metal Arc (SMAW) welding of Weld Joint CB3002A-018-014, And, Welder is identified as 054467, 048659,049769, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-P-2214-TC-U4b.

BAY 7

FCAW welding of Weld joint DP3181-001-036, And Welder is identified as 217185, ZPMC Quality Control (QC) is identified as Mr. Xu Hai Yang, The welding variables appeared to comply with the Applicable WPS-B-T-2233-B-U2-F.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07238

Ultrasonic Testing (UT)

This QA Inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The member is identified as Steel Barrier weld. The weld designations reviewed are as follows.

1. W2-SB9-042-019,050
2. W2-SB9-041-050
3. W2-SB9-040-081
4. W2-SB9-038-081
5. W2-SB9-033-081
6. W2-SB9-032-081
7. W2-SB10-017-050
8. W2-SB10-015-019,050
9. W2-SB10-014-050

BAY 8

FCAW welding of Weld joint BK004A2-055-021, And Welder is identified as 054459,500405 ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen The welding variables appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of Weld joint BK004A1-058-044, And Welding Repair Report (WR)B-WR16464, Welder is identified as 500405, ZPMC Quality Control (QC) is identified as Mr. Liu Fa Wen The welding variables appeared to comply with the Applicable WPS-345-FCAW-1G(1F)-Repair-1.

BAY 9

Visual Testing (VT)

This QA Inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Service Platform weld. The weld designations reviewed are as follows.

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1. SPEP2-004~008

Note:-Green Tag no.15062 has signed for above mentioned component.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
